

Split

Dart Aerospace Ltd.

Date: Monday, 02/03/2009 9:05:13 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46146 -/
 Estimate Number : 10564
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 44029
 Written By :
 Checked & Approved By : JUD 09.03.02
 Comment : Est Rev: A 05.11.14 New issue. EC

Drawing Name : STRUT WELDMENT ASS'Y
 Part Number : D34433
 Drawing Number : D3443 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 16/03/2009 Qty: 20 Um: Each

16.

20

20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M304R1500

304 round bar 1.500



M106260



Comment: Qty.: 0.2500 f(s)/Unit Total : 5.0000 f(s)

09/03/03

26 pcs

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: AADWG REV: B

2-DEBURR AS REQUIRED

09/03/03

26 pcs

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/03/03

26 pcs

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: B & Dwg D3443 Rev: B

2-Deburrr per dwg D3443

N.A 09/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-3 PAR #: N/A Fault Category: Prod/Machined part NCR: (Yes) No DQA: D Date: 09/03/16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/03/16

NCR: <u>46146</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/16</u>	<u>4.0</u>	<u>1 Part scrap</u> <u>The rougher 1" 5 flute broke</u> <u>during machining and so</u> <u>the part have turned in</u> <u>the collet.</u> <u>R.C: process</u>	<u>[Signature]</u> <u>09/03/16</u>	<u>Scrap: Part is already</u> <u>destroyed.</u> <u>No replace</u>	<u>[Signature]</u> <u>09/03/16</u>	<u>[Signature]</u> <u>09/03/16</u>	<u>[Signature]</u> <u>09/03/16</u>	<u>[Signature]</u> <u>09/03/16</u>

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:13 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46146

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B.A 09/03/05

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

SS 09/03/12 (16)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SS 09/03/12 (16)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 09/03/13

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl L.

SS 09/03/13 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/03/13

Job Completion



U 09.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 461460
Description: Clevis		Part Number: D3443-3
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.719	✓			
0.95	+/-0.030	.945	✓			
Ø0.500	+0.000/-0.005	.497	✓			
20°	+/-0.5°	20°	✓			
R0.450	+/-0.010	R0.450	✓			
Ø0.375	+0.006/-0.001	Ø0.377	✓			
0.451	+/-0.010	0.451 0.461	✓			
0.625	+/-0.010	.630	✓			manual mill
1.53	+/-0.030	1.525	✓			
0.720	+/-0.010	0.719				
0.05 x 45°	+/-0.5°	.045 x 45°	✓			
45°	+/-0.5°	45°	✓			
1.00	+/-0.030	1.001	✓			
1.125	+/-0.010	1.124	✓			
0.438	+0.005/-0.000	0.439	✓			
R0.050	+/-0.010	R0.050	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>J.L.</i>	Prototype Approval:	N/A
Date: 09/03/13	Date: 09/03/13	Date:	N/A

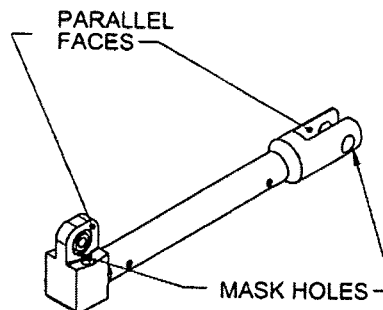
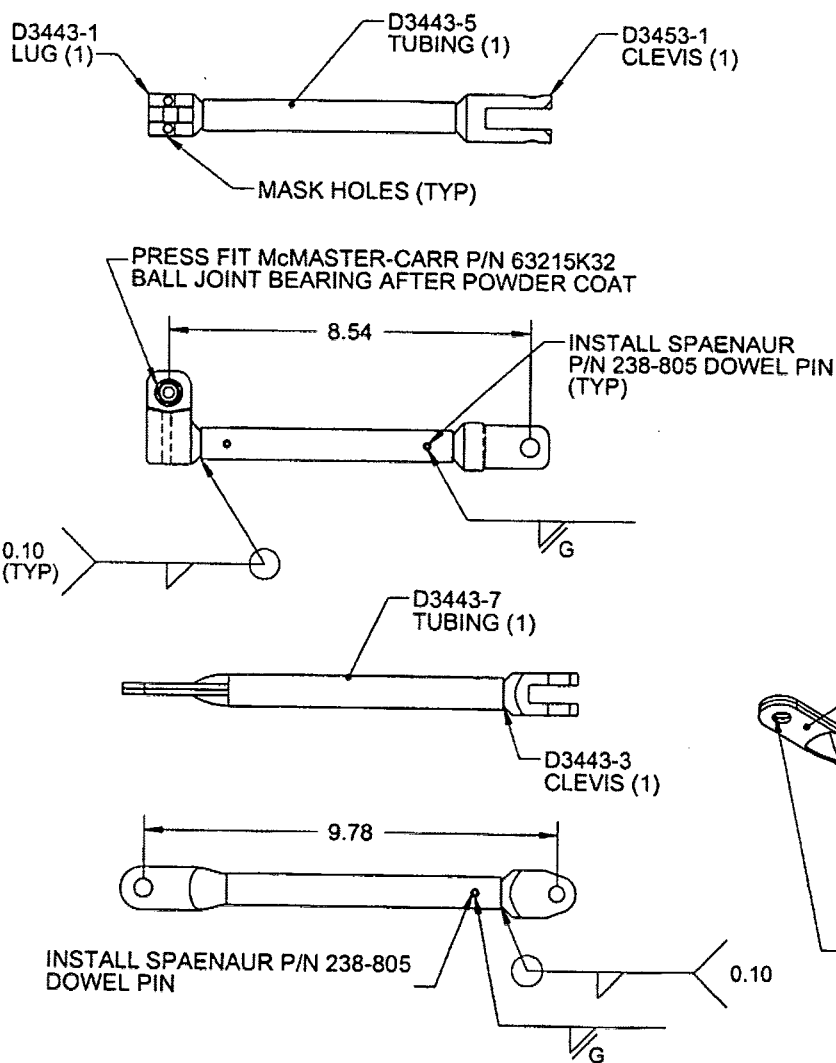
Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	<i>[Signature]</i>



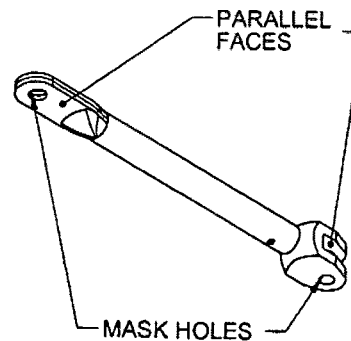
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED

05.12.09 *[Signature]*



D3443-041



D3443-043

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NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER

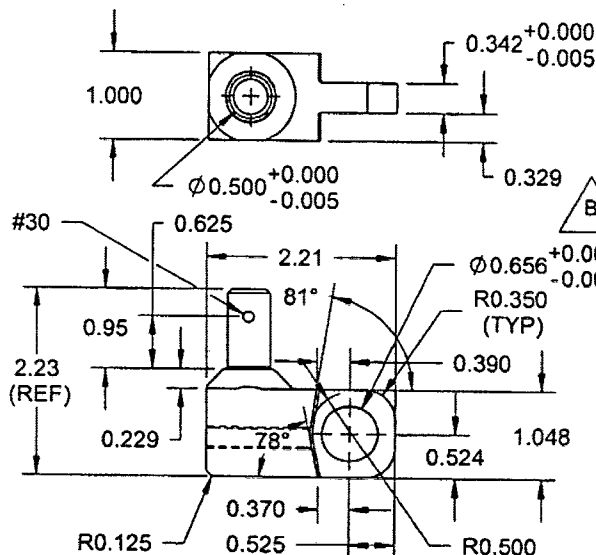
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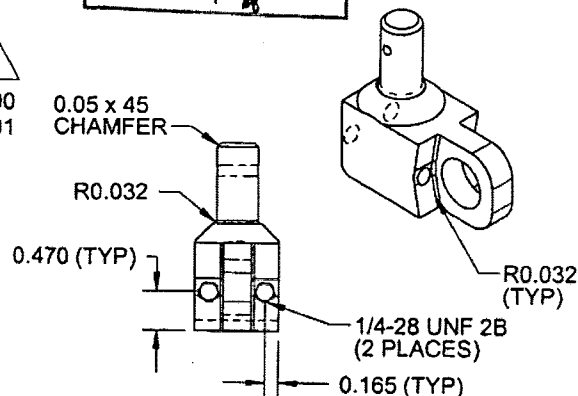
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		



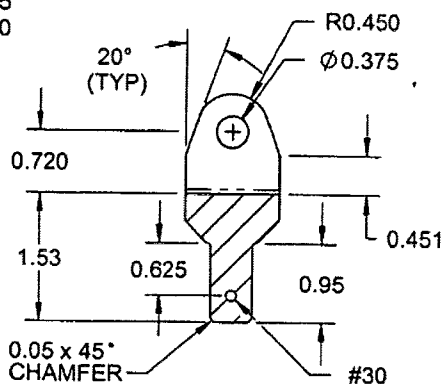
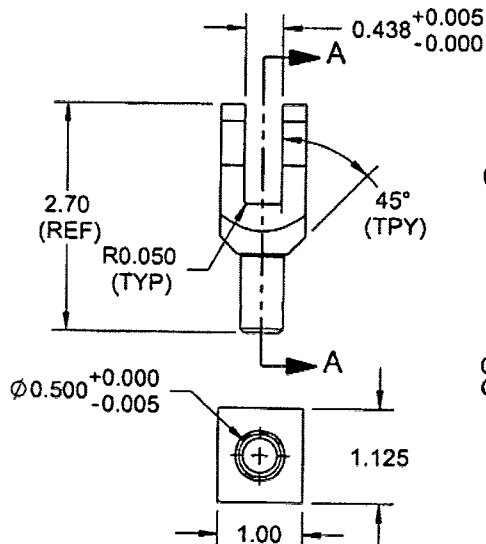
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05.12.04



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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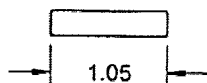
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

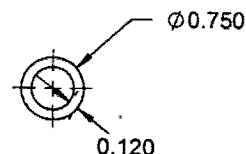
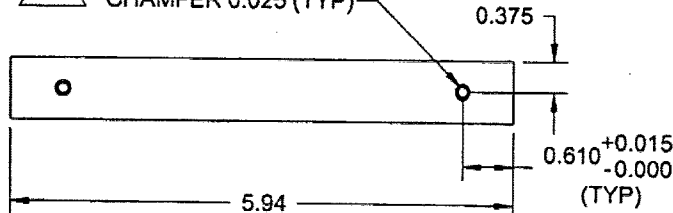
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

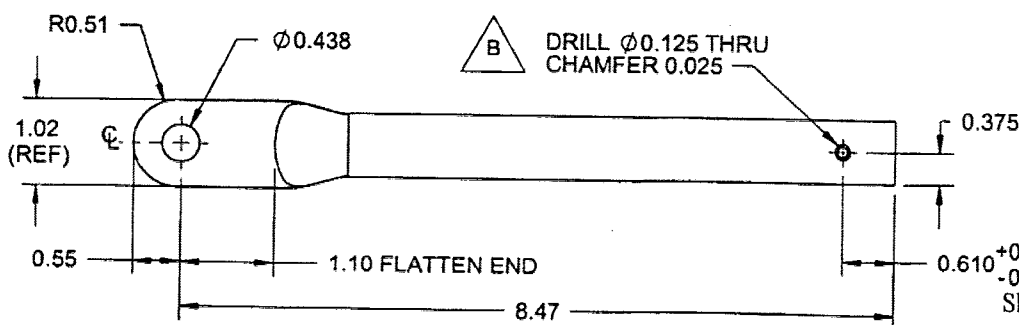
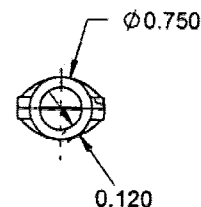
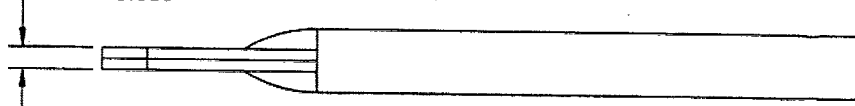


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750PW-120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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